

Date: Monday, 11/21/2005 1:16:27 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE		
Job Number	: 24854					
Estimate Number	: 10832					
P.O. Number	: N/A			Part Number	: D29322	
This Issue	: 11/21/2005 S.O. No. : N/A			Drawing Number	: D2932 REV B	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: B	
Previous Run	: N/A			Material	: N/A	
Written By	: See Comment Below			Due Date	: 12/21/2005	
Checked & Approved By	: See Above User & Date			Qty:	4 Um: Each	
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC					

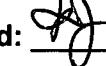
Additional Product

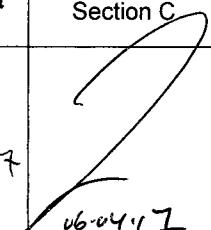
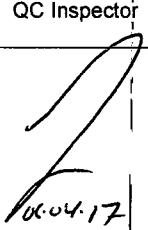
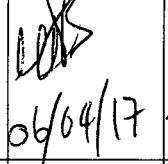
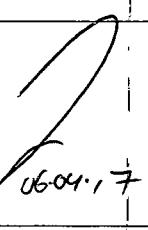
Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length Batch No: B 25347	J.L 06.04.17
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr	J.L 06.04.17 (1)
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	J.L 06.04.17 (1)
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	J.L 06.04.17 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2932-2 PAR #: N/A Fault Category: Prod / machined ^{parts} NCR: Yes No DQA:  Date: 06/04/17
QA: N/C Closed:  Date: 06.04.25

NCR: 04854		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.04.17	2	Chamber tool was too low from the Z+ axis run, and the tool ran in along the bottom of the saddle (view C-C) -0.40 deep. This will be too thin when channel gets machined.		Scrap & destroy. Rebuild as noted below.	J.L 06.04.17			
06.04.17	2	D2932-2 B26371 was made on w/o D2932-2 B26371. See far electronics.		Add D2932-2 B26371 to replace scrap saddle (above) on this w/o See Attached.	J.L 06.04.17			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 1:16:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 24854

Part Number: D29322

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
7.0	POWDER COATING	POWDER COATING
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
9.0	PACKAGING 1	PACKAGING RESOURCE #1
10.0	DC	DOCUMENT CONTROL

Job Completion



U 06.04.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.123	.124	.125	.124		
B	0.100	0.140		.122	.123	.123	.123		
C	0.100	0.140		.128	.128	.126	.127		
D	0.210	0.230		.224	.220	.220	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.499	2.500	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686	✓	✓	✓	✓		
M	0.235	0.240		.239	.239	.240	.240		
N	0.100	0.140		.117	.118	.114	.116		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.500	.501	.501	.500		
Q	3.715	3.725		3.720	3.719	3.719	3.720		
R	2.470	2.510		2.502	2.500	2.500	2.500		
S	0.240	0.270		.252	.252	.252	.252		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.629	1.630	1.630	1.629		
V	1.362	1.372		1.367	1.368	1.367	1.367		
W	0.316	0.321	DT8690						
X	1.125	1.145		1.134	1.134	1.133	1.133		
Y	1.565	1.585		1.573	1.573	1.572	1.572		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL	Audited by:	EB
Date:	06.04.17	Date:	06/04/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No : 0024854
Project Name : D2932-2 Department Code:
Project For : WK551 Burden Flags : NNNNNNN
Work Order Type : Main WO Status : Open
Main WO Number : Invoice State : Not Invoiced
House Part Number : D2932-2 Invoice Date :
Description : 206 Saddle Right side Invoice Number :
Manufactured : Yes Invoice Amount : 0.00
Amount Req'd : 4
Amount Done : 0 Order Entry No :
Start Date : 11-17-05 OE Value : 0.00
Est Finish Date : 12-21-05
Act Finish Date : Est Margin : 0.000%
Drawings Reqd : No Actual Margin : 0.000%
Ok for Approval :
Approval Rec'd : \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss)	0.00	0.00

Date: Thursday, 3/23/2006 3:52:24 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE		
Job Number	: 26371		Part Number	: D29392		
Estimate Number	: 10937		Drawing Number	: D2939 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 3/23/2006	S.O. No. :	Drawing Revision	: B		
Prsh Rev.	: NC		Material	:		
First Issue	: 3/23/2006	Type :	Due Date	: 4/10/2006 Qty: 4 Um: Each		
Previous Run	: 24961					
Written By	:					
Checked & Approved By	: <i>JL 06.03.24</i>					
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC					

Additional Product

Job Number:



REFERENCE ONLY

Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
5.0	QC8	SECOND CHECK

Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Issue material from stock: 7075-T7351 (QQ-A-250/12)
 Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length *B24890*
 Batch No: *6.25/37* JL 06.04.15

Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
 5-Deburr JL 06.04.16 (4)

Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet JL 06.04.16 (4)

Comment: INSPECT ALL DIM TO DIM SHEET JL 06.04.16 (4)

Comment: SECOND CHECK JL 06.04.16 (4)

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.04.17	2	Wrong program run on machine. WID2932-2 was made B# B26371. Operator error, punched in wrong folio #	JL	Fix folio to A § 2939-2 B26371. Add WID2932-2 B26371 to W/O WID2932-2 B24854. Replace Spare	J.L 06.04.17	J.L 06.04.17	JL 06/04/17	JL 06/04/17

NOTE: Date & initial all entries